

# Work Order ID 81110

**\*81110\***

Page 1

March-08-12 8:50:55 AM

Item ID: D3391-025 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Aft Tube Assembly  
 Start Date: 08/03/2012 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 22/03/2012 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/09 Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3391	I

100 0.00  
**\*100\*** MORI SEIKI CNC LATHE LARGE  
 Mori Seiki Memo 0.00  
 Mori Seiki CNC Lathe Large Turn as per Folio FA599 Rev: AA & Dwg D3391 Rev: I  
 \*\*\*scribe batch # on fwd end at 90 degree\*\*\*

1 Ø  
man.L 12/03/19

110 0.00  
**\*110\*** QC2- Inspect parts off machine FAI/FAIB  
 QC Memo 0.00  
 Quality Control

1 Ø  
man.L 12/03/19

111 0.00  
**\*111\*** QC8- Inspect parts - second check  
 QC Memo 0.00  
 Quality Control \*\*\*INSPECT INSIDE BORE\*\*\*

BA 12/03/24

1 Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Item ID: D3391-025

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Aft Tube Assembly

Start Date: 08/03/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 22/03/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

0.00

**\*150\***

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Drill ( PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

CF 12-3-27

160

0.00

**\*160\***

BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

Form as per Dwg D3391 Using Bend Prog 3391025

DL 12/03/27

170

QC5- Inspect part completeness to step on W/O

0.00

**\*170\***

QC

Memo

0.00

Quality Control

4,15"

JP 12-3-27

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Aft Tube Assembly

Start Date: 08/03/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 22/03/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

0.00

\*180\*

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill float bag holes using DT8809 as per Dwg D3391 (Holes marked "A" Only)

3-Drill wearplate holes as per Dwg D3391 using DT8878 (Mid Tube) & DT8217 Wearplate Jig

\*\*\*\*\*Do Not Open To Finished Size\*\*\*\*\*

4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2 previously drilled aft wearplate holes.

5-Open wearplate holes to 0.250" and c'bore as per dwg D3391

6-Open up all wearshoe, wearplate to 0.297" and float bag holes to 0.328" as per Dwg D3391.

7-Deburr

De 12/03/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 <b>*190*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00							
200 <b>*200*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00							
210 <b>*210*</b> QC Quality Control	QC3- Inspect Part Finish QC7 Memo	0.00 0.00							




5/12/28

OK 12/03/28

DP 12-3-28

PTO

**Dart Aerospace Ltd**

W/O: 8110		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12-3-28	210	Should read QC7		12-3-28		 204.02	 12/3/08

Part No: D3391-025 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Start Date: 08/03/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 22/03/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

220

0.00

**\*220\***

Skidtubes

0.00

Skidtubes

Memo

Instal spacers as per dwg D3391  
A/R Magnabond 6398 Batch: 120666  
exp. date: 13/01/30  
cure time 12hrs as per QSI0015

230

0.00

**\*230\***

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

Quality Control

235

0.00

**\*235\***

Pressure Wash per QSI005 4.3

0.00

HandFinish

Memo

Hand Finishing

AND REALODINE AS PER PAR09-043

7 02/12/03/28

8/12/03/29

1X4 m-12/03/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Item Name: Aft Tube Assembly

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**\*N900040100\***

Setup Start **\*NS1\***  
Stop **\*NS2\***

Start Date: 08/03/2012 Start Qty: 1.00 **\*1\***  
Required Date: 22/03/2012 Req'd Qty: 1.00 **\*1\***

Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***  
Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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240	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
-----	--	------	--	--	--	--	--	--	--

**\*240\***

Powdercoat

Powder Coating

Memo

START TIME: 3:00  
OVEN TEMPERATURE: 320°F  
FINISH TIME: 3:30

*1X m.f 12/03/30*

250	QC3- Inspect Part Finish	0.00							
-----	--------------------------	------	--	--	--	--	--	--	--

**\*250\***

QC

Quality Control

Memo

*1 of 12/04/02*

260	HandFinishing	0.00							
-----	---------------	------	--	--	--	--	--	--	--

**\*260\***

HandFinish

Hand Finishing

Memo

- ✓ 1-Install inserts as per Dwg D3391
- ✓ 2-Install Aft Cap as per Dwg D3391
- ✓ A/R Sikaflex-241/-291 *12/03/08*  
Sikaflex expiry date: *12/02*
- ✓ 3- INSTALL WEARPLATES AS PER DWG

*1 of 12/04/02*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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**\*81110\***

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March-08-12 8:50:55 AM

Item ID: D3391-025  
Revision ID:  
Item Name: Aft Tube Assembly  
Start Date: 08/03/2012 Start Qty: 1.00  
Required Date: 22/03/2012 Req'd Qty: 1.00  
Reference:

Accept

**\*N900040100\***

Setup Start **\*NS1\***  
Stop **\*NS2\***

Cust Item ID:  
Customer:

**\*1\***  
**\*1\***

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***  
Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270	QC5- Inspect part completeness to step on W/O	0.00							
<b>*270*</b>		0.00							
QC	Memo	0.00							
Quality Control									
280	Identify as per dwg & Stock Location: <u>w/o</u>	0.00							
<b>*280*</b>		0.00							
Packaging	Memo	0.00							
Packaging									
290	QC21- Final Inspection - Work Order Release	0.00							
<b>*290*</b>		0.00							
QC	Memo	0.00							
Quality Control									

*8/26/02*

*D412-742-043/*

*1381093*

*1 of 111 12/04/02*

*MLJ 12/04/02*

*D12-04-2*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

March-08-12 8:50:58 AM

Page 1

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Work Order ID: 81110

\*81110\*

Parent Item: D3391-025

\*D3391-025\*

Parent Item Name: Aft Tube Assembly

Start Date: 08/03/2012

Required Date: 22/03/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev B 06-02-07 ECN773 dwg rev. D EC  
 IPP Rev:C 06-03-28 Update Manuf. Instructions JLM  
 IPP rev D 07.03.20 revF dwg EC  
 IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD  
 IPP Rev:F 07-11-13 ECN 1056 DD verified by: EC  
 IPP Rev:G 08-09-10 revH as per dwg DD verified by:EC IPP Rev:H  
 11.11.14 AS PER REV.I DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4095-047		Manufactured	No			260	Each	19.0000	1	1			
*D4095-047*													
Wearpad Assembly													
**													
JK 12/04/02													

Location	Loc Qty	Loc Code
FP002	19	
78325	5	
80703	14	

D4095-049		Manufactured	No			260	Each	15.0000	1	1			
*D4095-049*													
Wearpad Assembly													
**													
JK 12/04/02													

Location	Loc Qty	Loc Code
FP002	15	
80704	15	

D6014-090		Manufactured	No			100	Each	43.0000	1	1			
*D6014-090*													
ALUMINUM EXTRUSION													
**													

Location	Loc Qty	Loc Code
LG	43	
77332	43	

1 man.L 12/03/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*81110\***

Parent Item: D3391-025

**\*D3391-025\***

Parent Item Name: Aft Tube Assembly

Start Date: 08/03/2012

Required Date: 22/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3670-4-200

Manufactured No

230

Each

63.0000

4

4

**\*D3670-4-200\***

SPACER

\*\*

DC 12/03/28

Location

B80360

Loc Qty

Loc Code

LG001

63

72851

3

77500

4

78606

56

(4)

D2646

Manufactured No

270

Each

146.0000

1

1

**\*D2646\***

Aft Cap

\*\*

HL 12/04/02

Location

Loc Qty

Loc Code

FP002

146

62678

5

68280

5

70945

1

71070

2

73294

1

73825

2

78018

33

79500

47

79562

50

X 1

D3672-1

Manufactured No

270

Each

1,294.000

2

2

**\*D3672-1\***

Phenolic Washer

\*\*

HL 12/04/02

Location

Loc Qty

Loc Code

FP001

242

66821

242

ST060

1052

72229

52

76277

500

80369

500

X 2

March-08-12 8:50:59 AM

Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*D3391-025\***

Parent Item Name: Aft Tube Assembly

Start Date: 08/03/2012

Required Date: 22/03/2012

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130

Purchased

No

260

Each

4,855.000

14

14

**\*AI S4-1032-130\***

**\*\***

*u 12/04/02*

Insert

Location

Loc Qty

Loc Code

ST280

681

119084

116

120671

565

ST281

4174

120410

174

120807

2000

120837

2000

*x14*

ALS4-1032-225

Purchased

No

270

Each

1,194.000

8

8

**\*AI S4-1032-225\***

**\*\***

*u 12/04/02*

Insert

Location

Loc Qty

Loc Code

ST281

1031

108696

146

110768

62

118386

55

118966

68

120671

700

ST282

163

120410

150

120451

13

*x8*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item: D3391-025

\*D3391-025\*

Parent Item Name: Aft Tube Assembly

Start Date: 08/03/2012

Required Date: 22/03/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C4A Purchased No

270 Each

3,729.000 6 6

\*AN3C4A\*

BOLT

\*\*

ul 1204102

## Location

## Loc Qty

## Loc Code

ST350

3729

117688

5

118112

16

119749

10

120187

2000

120423

10

120521

510

120769

515

120799

163

120930

500

AN3C5A Purchased No

270 Each

1,010.000 4 4

\*AN3C5A\*

Bolt

\*\*

ul 1204102

## Location

## Loc Qty

## Loc Code

FP001

7

115835

7

ST350

1003

116419

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

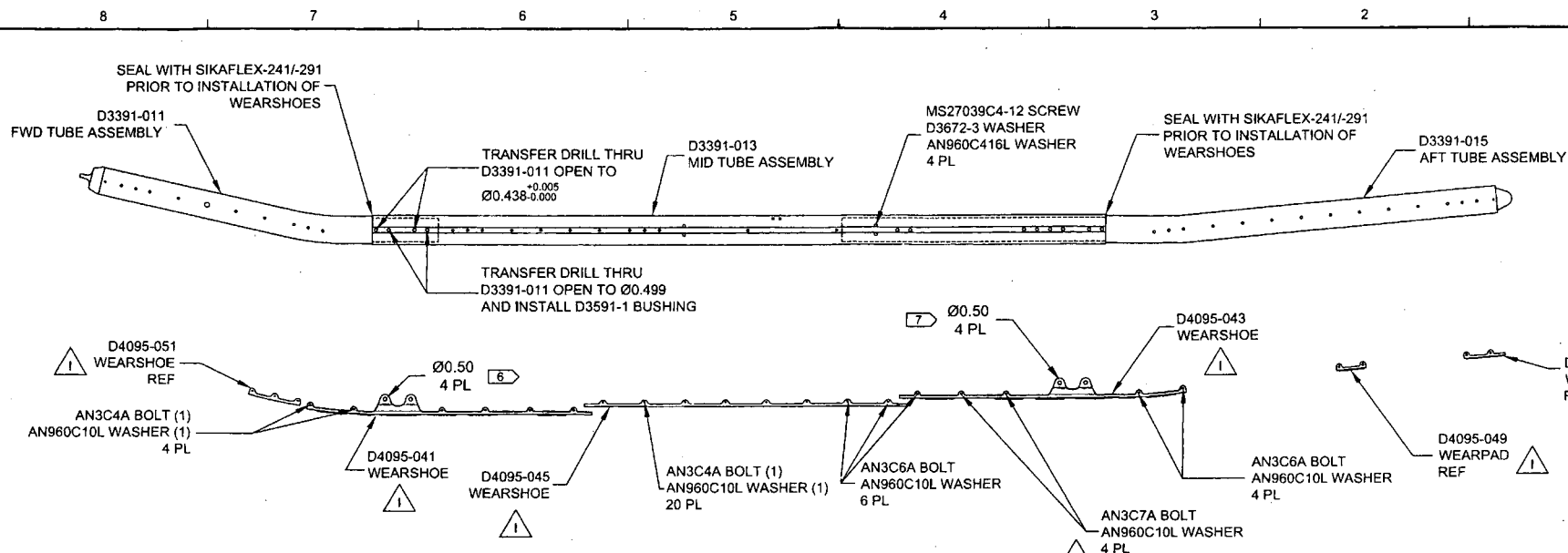
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST**

QTY -041	PART NUMBER	DESCRIPTION
X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
4	D3672-3	WASHER
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARSHOE
1	D4095-049	WEARSHOE
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

**GENERAL NOTES**

- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

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BCN# 11-662

I	REMOVE GASKETS AND REPLACE ALL WEARSHOES; PARTS LIST UPDATE, ZN A8-1, ZN A8-2, ZN A6-4, ZN B6-8; LPS-3 COATING REMOVED FROM NOTE 2, ZN A3-1, ZN A3-2, REMOVED INSERT AELS-1032-130, ZN B6-4, B2-4, C7-8, C3-8; REMOVED HOLES, ZN D6-4 ZN D2-4, ZN D7-8, ZN D3-8	XDF	11.10.13
H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING, ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING, ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
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MFG. APPR.		D3391	SHEET 1 OF 8
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DATE	11.10.13	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC	

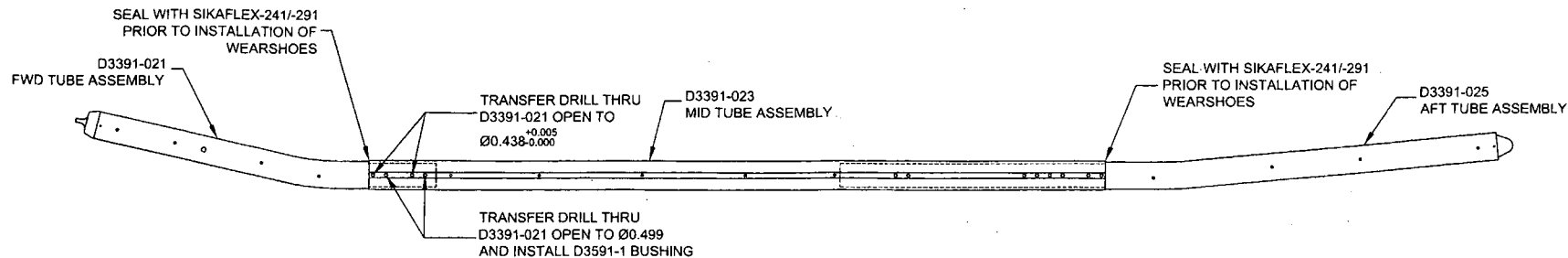
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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#### D3391-043 ASSEMBLY

#### D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARPAD
1	D4095-049	WEARPAD
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER

#### GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON"  
AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES  
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT  
WHERE INDICATED.
- 6) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH  
APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND  
TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 7) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH  
THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND  
TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

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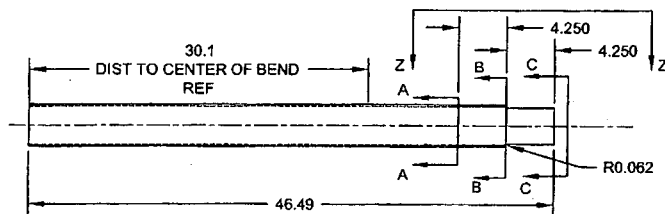
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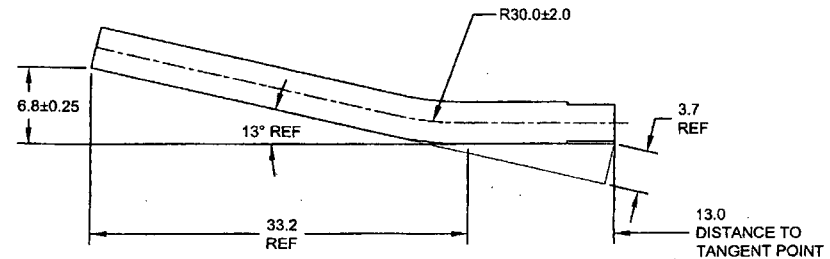
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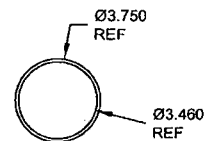
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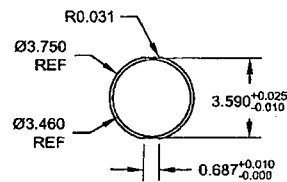
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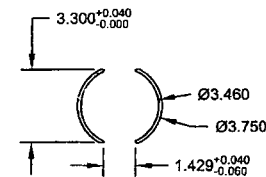
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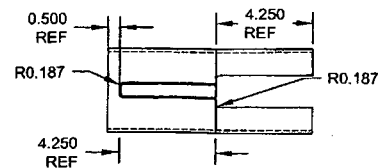
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**SECTION B-B**  
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**SECTION C-C**  
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**VIEW Z-Z**  
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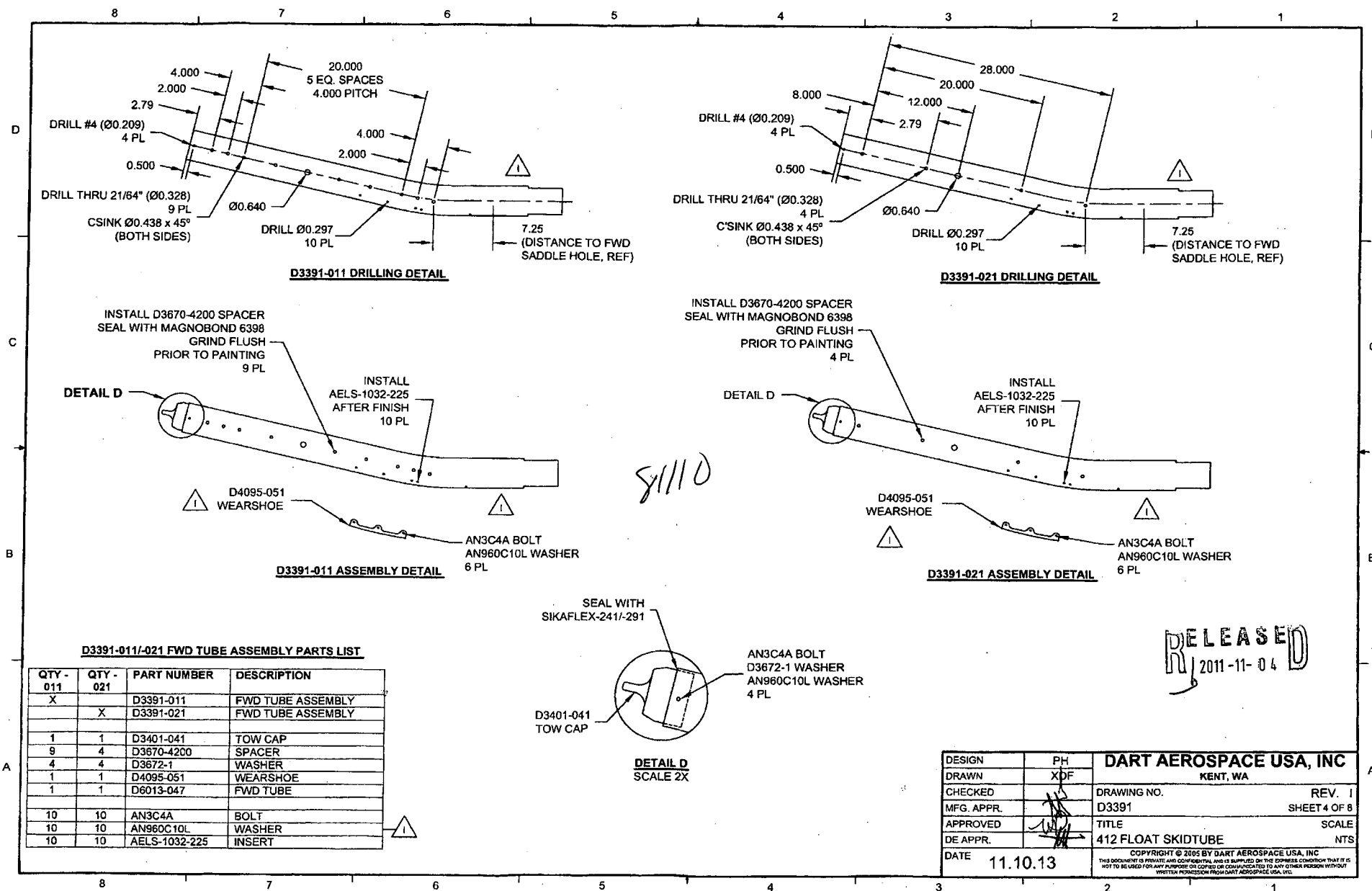
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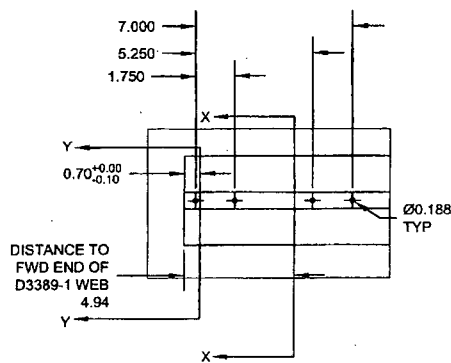
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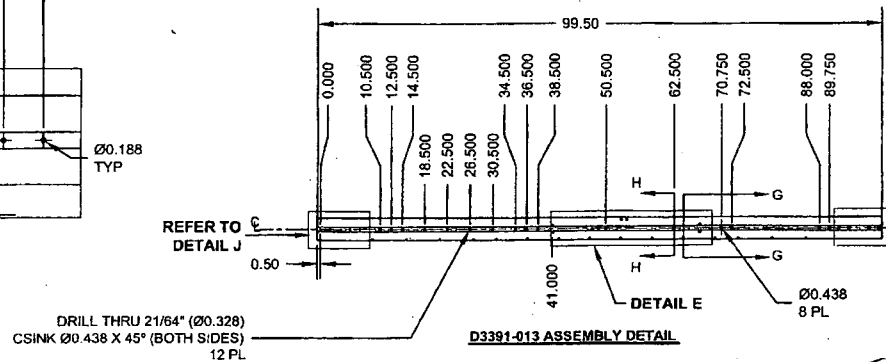
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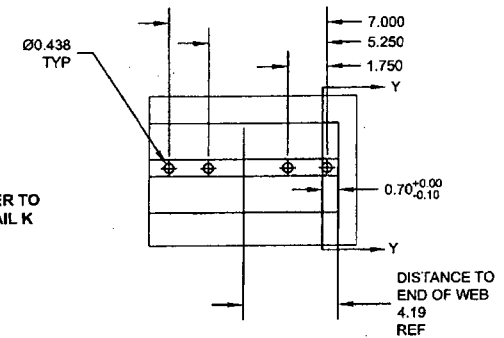
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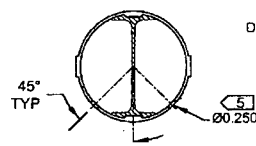
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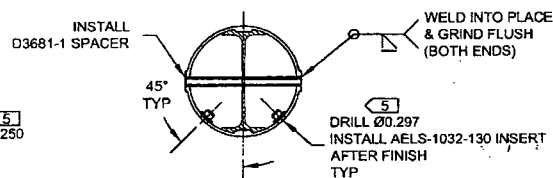
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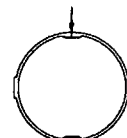
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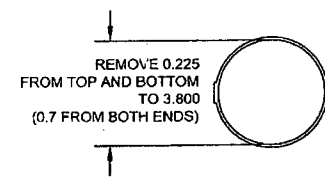
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SECTION H-H  
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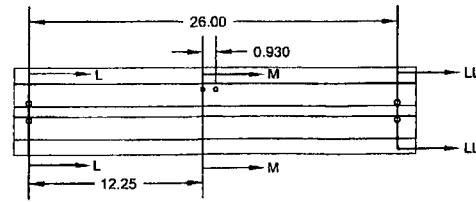
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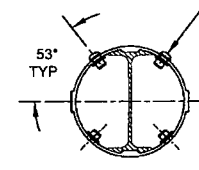
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D3391-013 MID TUBE ASSEMBLY PARTS LIST

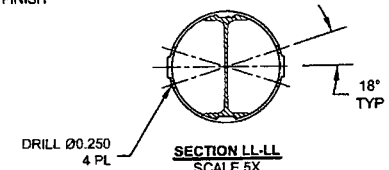
QTY	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW



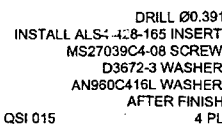
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SECTION M-M  
SCALE 5X



SECTION LL-LL  
SCALE 5X



SECTION L-L  
SCALE 5X

D3391-013 MID TUBE ASSEMBLY

- MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- WELDING: PER DART QSI 004

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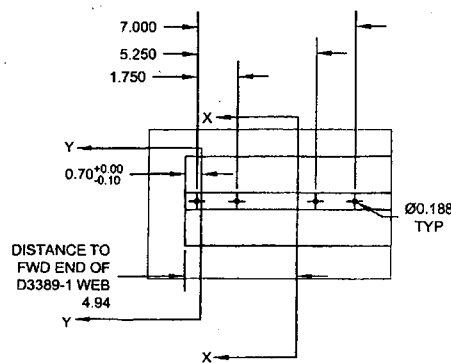
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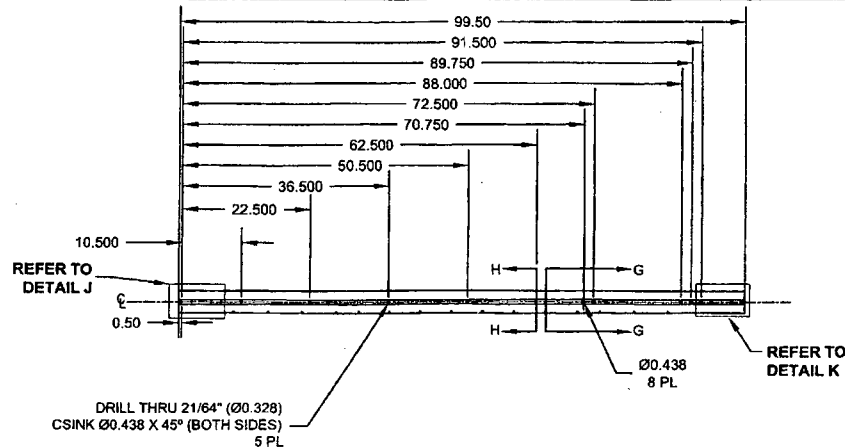
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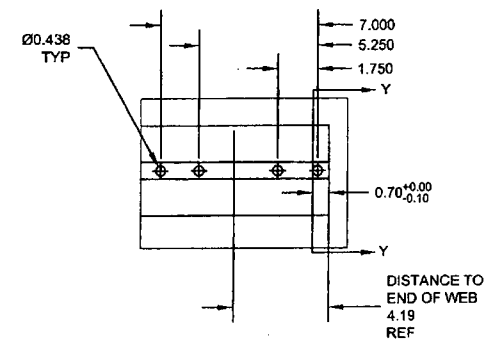
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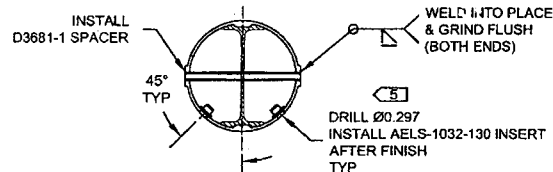
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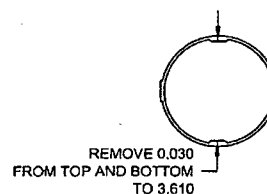
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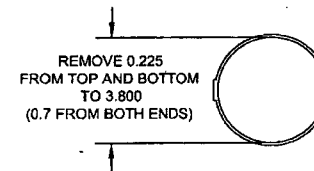
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**SECTION H-H**  
SCALE 5X



**SECTION X-X**  
SCALE 5X



**SECTION Y-Y**  
SCALE 5X

**D3391-023 MID TUBE ASSEMBLY PARTS LIST**

QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

**D3391-023 MID TUBE ASSEMBLY**

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

8/11/10

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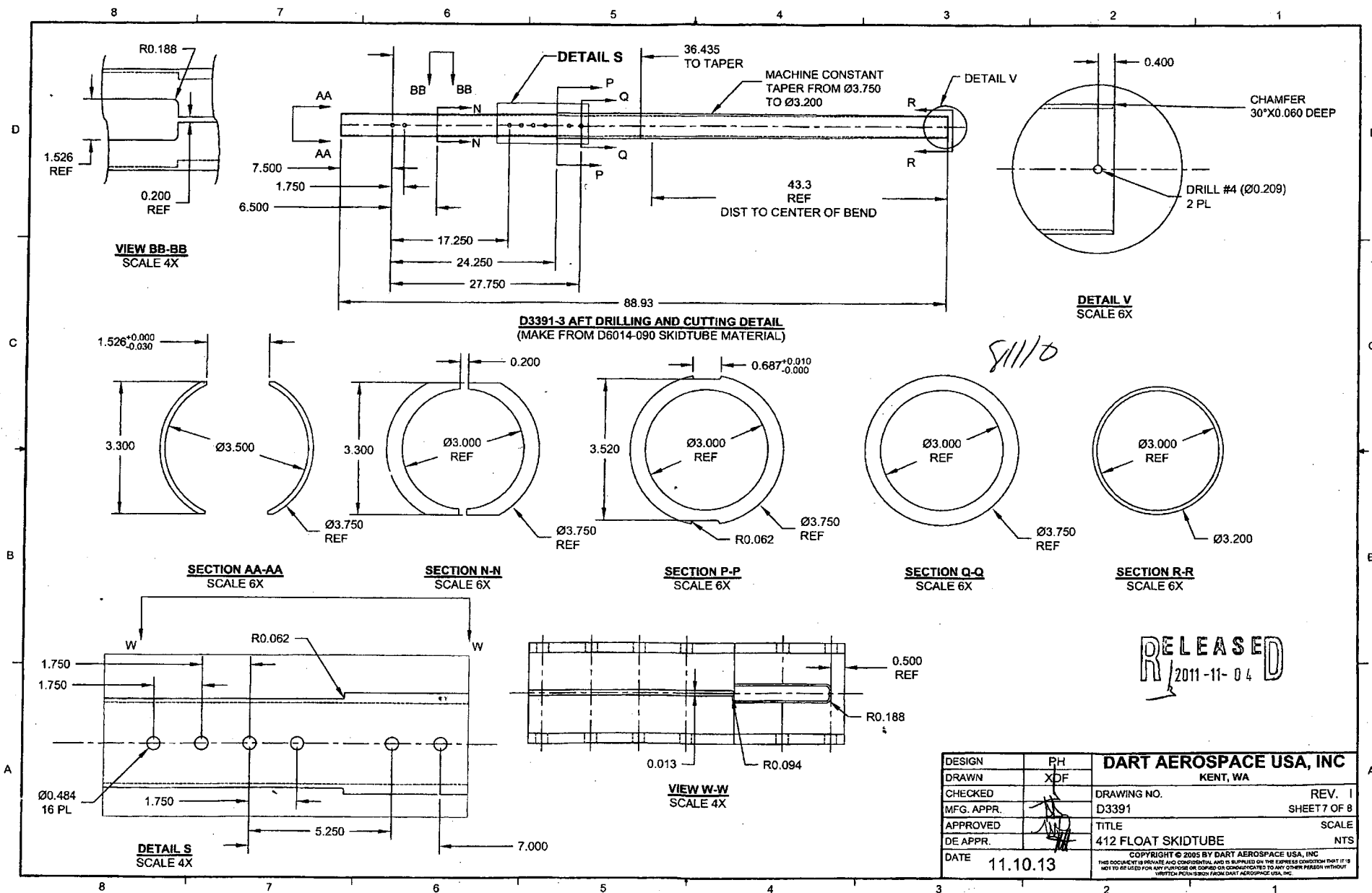
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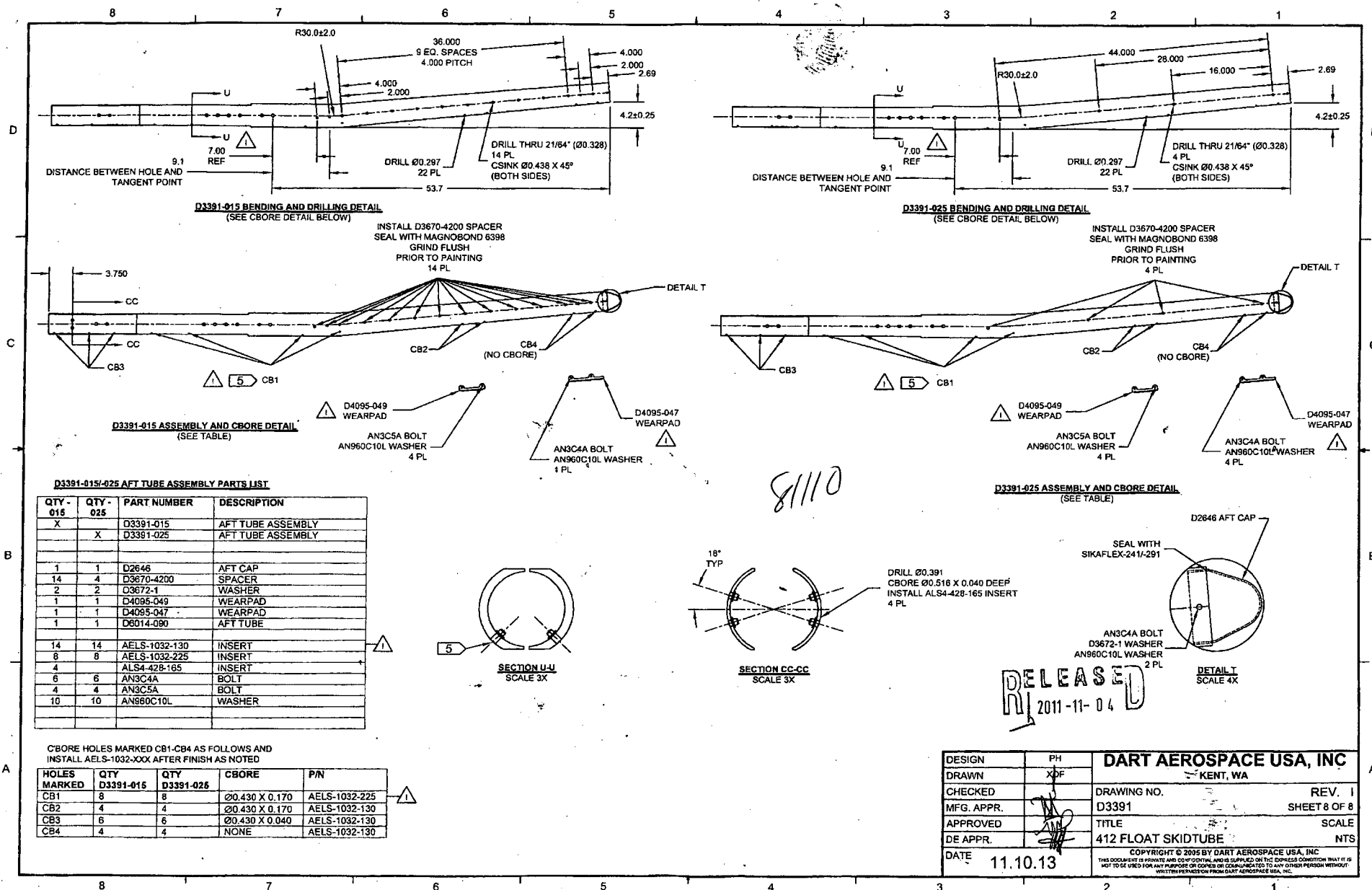
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 81110
<b>Description:</b> Float Skidtube (412)		<b>Part Number:</b> D3391-3
<b>Inspection Dwg:</b> D3391	<b>Rev:</b> H I 4	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
<b>Lathe Section</b>						
14.000	+/-0.010	14.00	/		tape	MM L-02
3.500	+/-0.010	3.503	/		vern	CNC-08
88.93	+/-0.030	88.93	/		tape	MM L-02
Ø3.200	+/-0.010	3.198	/		vern	CNC-08
88.93	+/-0.030	88.93	/		tape	MM L-02
Ø3.750	+/-0.010	3.750	/		vern	CNC-08
30° x 160° chamfer	+/-0.010	30° x 16	/		11	

<b>Measured by:</b> MM	<b>Date:</b> 12/03/16
<b>Audited by:</b> B.A	<b>Date:</b> 12/03/24

<b>HAAS Section</b>						
1.526	+0.000/-0.030	1.515	/		vern	SD3
7.500	+/-0.010	7.500	/			
27.750	+/-0.010	27.750	/		m. tape	
31.750	+/-0.010	31.750	/			
35.250	+/-0.010	35.250	/			
3.300	+/-0.010	3.305	/		vern	-
0.200	+/-0.010	.206	/			
3.520	+/-0.010	3.523	/			
0.687	+0.010/-0.000	.690	/			
R0.062	+/-0.010	.062	/			
Ø0.484	+0.005/-0.001	.487	/			

<b>Measured by:</b> SL	<b>Date:</b> 12-03-23
<b>Audited by:</b> B.A	<b>Date:</b> 12/03/24

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	
H	11.06.21	Dimension 44.995 removed	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries